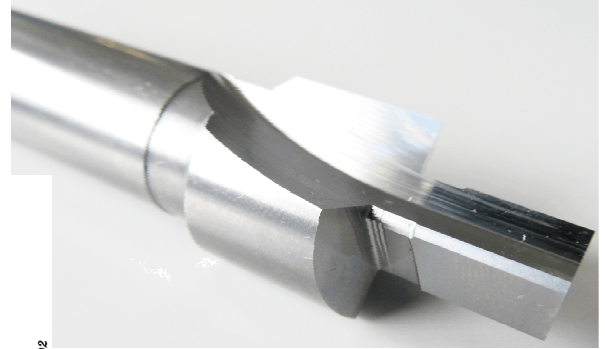
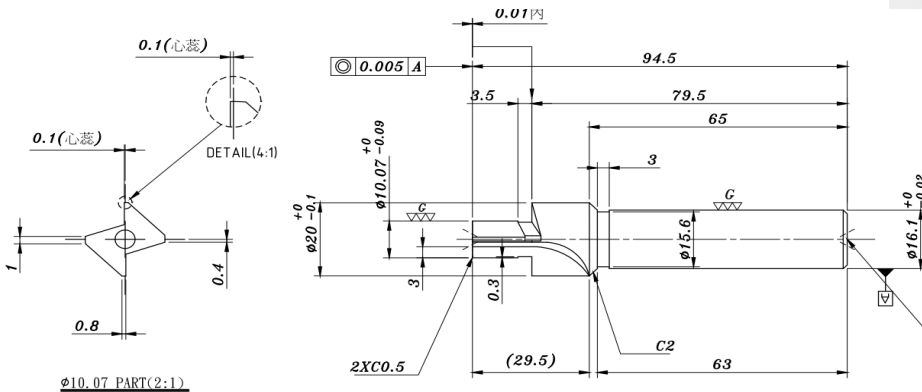


Stepreamer Ø10.07-Ø20

A15-200

This tool is basically not a finished tool, it is the shank before soldering of PKD inserts. The OD grinding was done before on a cylindrical grinding machine.



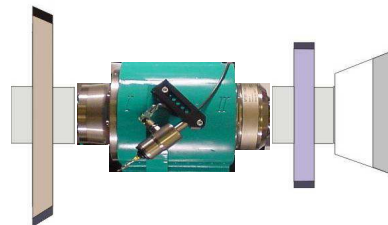
1. Cycletime for Production

Workpiece:	end-Ø10.07-Ø20, shank-Ø16.1 mm, Z 2, Length 29 mm, Helix angle 0° Material CARBIDE					
Operations						
Feed [mm/Min]	2000	15	20	30	60	50
Power [kW]		2	1	1	1	1
Cutting speed [m/s]		20	20	22	22	22
Used wheels						
Grinding time [s]	9	268	198	82	46	450
Total cycle time	17 Min 34					

The cycle times are indicative. Material to be ground, grinding wheels, coolants can influence the cycle times considerably.

2. Used Grinding Wheels

1	1A1 Ø100 D76
2	11V9 Ø100 D76
3	1V1 Ø125 D76



3

1

2

3. Machine and Software Requirements

Machines: 5 axes CNC grinders : GEMINI DMR

Coolant: Synthetic Oil, pressure 6 bar

Control: Fanuc 31iA5

Software: Quinto 5

Accessories:

Responsible engineer: OP, 28.2.13

www.schneeberger.ch

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